

Work Order ID 55282

January 12, 2010 3:08:46 PM

Page 1

Item ID: D3694-1

Accept

Revision ID:

Item Name: Mounting Plate

Start Date: 1/12/2010 Start Qty: 4.00

Required Date: 1/19/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: *CMF*Date: *10-1-12*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3694

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 7.150" long

*ent 10/01/12**4 0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA731 Rev: *HA* & Dwg D3694 Rev: *C* 2-Tap 10-32 heli-coil holes Manually 2-Deburr per dwg D3694*ent 10/01/13**4 1*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*ent 10/01/13**4 1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3694-1 PAR #: N/A Fault Category: Machine NCR: ☒ Yes ☐ No DQA: W Date: 10.01.19
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: X Date: 10/01/26






NCR: <u>55282</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/01/12</u>	<u>110</u>	<u>1 part scrap the dim. 125</u> <u>±.020 was .085"</u> <u>R.C. roughing tool make</u> <u>a top big pass one shot.</u> <u>and more up the part</u>	<u>[Signature]</u> <u>Chief Eng</u>	<u>destroy</u> <u>replace Qty</u> <u>Ratch M110556</u> <u>Position fixed by MC</u>	<u>[Signature]</u> <u>10/01/13</u>	<u>S</u> <u>colat/13</u>	<u>[Signature]</u> <u>Chief Eng</u>	<u>S</u> <u>colat/13</u>



NOTE: Date & initial all entries




Work Order ID 55282

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Item ID:	D3694-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Mounting Plate				Stop	
Start Date:	1/12/2010	Start Qty: 4.00		Cust Item ID:		
Required Date:	1/19/2010	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00	N.A	10/01/13		4	0		
QC Quality Control	Memo	0.00							
140 	Chemical Conversion Coat per QSI005 4.1	0.00	M	10/01/14		(X4)	0		
HandFinish Hand Finishing	Memo	0.00							
150 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat Powder Coating	Memo *****Mask all in surface as per Dwg D3694*****START TIME: 3:00pm COVEN TEMPERATURE: 3:30p FINISH TIME: 320017	0.00				(X4)	9		

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3694-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Plate

Start Date: 1/12/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 1/19/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

SK 10-01-15

(4)

170



Packaging

Identify as per dwg & Stock Location: 250

0.00

Packaging

Memo

0.00

10-1-15 (4) SD

180



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

10/01/18 HJ
MR 10-1-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 55282



Parent Item: D3694-1



Parent Item Name: Mounting Plate

Start Date: 1/12/2010

Required Date: 1/19/2010

Comments: IPP Rev:A New Issue 09-01-13 JLM Verified By:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X06.00 0		Purchased	No				f	15.5900	2.5213			



6061T6 BAR 1.00 X 6.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

15.59

110550

15.59

2.5213 *7m 10/01/12*

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 55282
Description: Keyway		Part Number: D3694-1
Inspection Dwg: D3694	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	Ø.206	—			
0.673 deep	+/-0.010	.680	—			
Ø0.257	+0.006/-0.001	Ø.259	—			
0.200 deep	+/-0.010	.201	—			
6.75	+/-0.030	6.749	—			
6.000	+/-0.010	6.000	—			
4.000	+/-0.010	4.000	—			
1.000 pitch	+/-0.010	1.000	—			
0.375	+/-0.010	.380	—			
4.114	+/-0.010	4.118	—			
1.375	+/-0.010	1.382	—			
2.000	+/-0.010	2.003	—			
2.500	+/-0.010	2.497	—			
Ø0.204	+0.005/-0.001	Ø.207	—			
0.500	+/-0.010	.500	—			
4.602	+/-0.010	4.600	—			
1.000	+0.010/-0.000	1.001	—			
0.13 x 45°	+/-0.030 x 0.5°	0.118 x 45°	—			
R0.13	+/-0.030	R.130	—			
0.88	+/-0.030	.883	—			
0.125	+0.030/-0.000	.132	—			
5.60	+/-0.030	5.602	—			
3.60	+/-0.030	3.605	—			
2:020	+0.050/-0.000	2.025	—			
0.505	+0.000/-0.005	0.502	—			
1.0	+/-0.030	1.000	—			
1.791	+/-0.010	1.788	—			
2.301	+/-0.010	2.301	—			

Measured by: <i>SM</i>	Audited by: <i>H.A</i>	Prototype Approval:	N/A
Date: 10/01/13	Date: 10/01/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	<i>[Signature]</i>

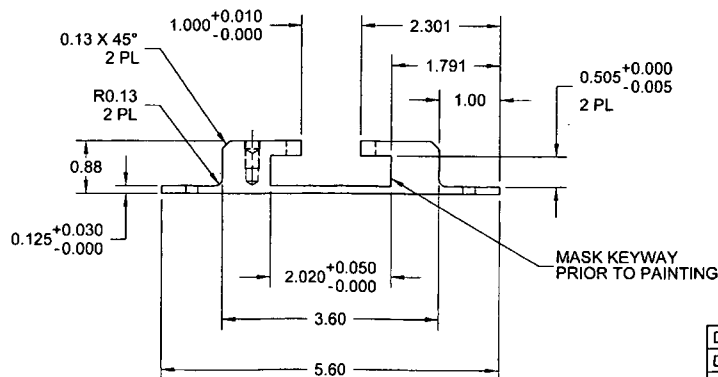
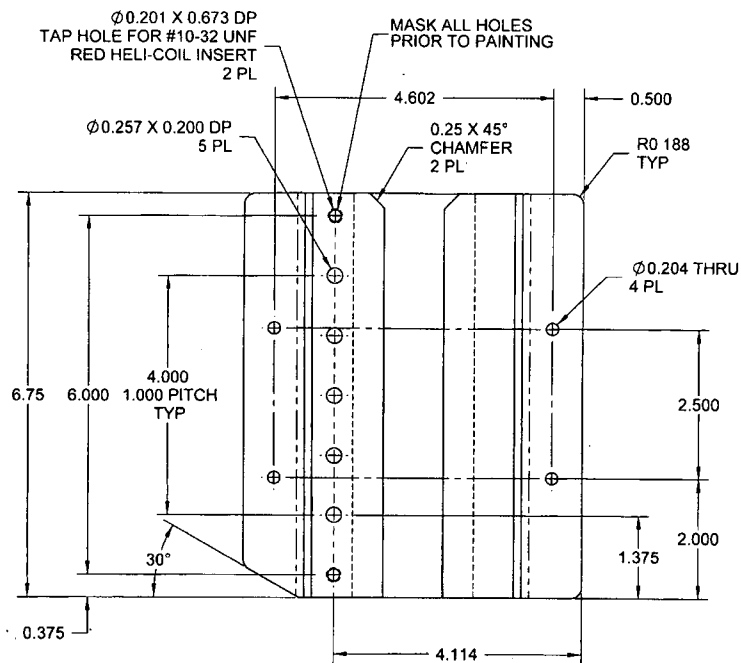
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D3694-1 KEYWAY

D3694-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

RELEASED
9/10/03

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3694	REV. C
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.11.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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